ASAP

Work Order ID 127021 *127021* Page 1 Wednesday, December 03, 2014 4:10:01 PM Item ID: D3503-1 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Cup *40* **Start Qty: 40.00 Start Date:** 12/04/14 **Cust Item ID:** Required Date: 12/05/14 Rea'd Otv: 40.00 *40* **Customer:** Reference: Start Run Date: 14-12-03 Tooling: **Approvals: Process Plan:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ **Tool ID** Tool # Plan Reject Reject Accept Insp. Number **Work Center ID Description** Qty Stamp **Run Hours** Code **Qty Draw Nbr Revision Nbr** D3503 Rev A 100 0.00 Hardinge CNC LATHE SMALL *100* 0.00 Hardinge Memo Hardinge CNC Lathe Small 1-TURN AS PER FOLIO FA635 & DWG D3503, FOLIO REV: WA DWG REV: A 2-DEBURR AS REQUIRED QC2- Inspect parts off machine FAI/FAIB 0.00 110 *110* **B**G 410 QC 0.00 Memo 14.12.07 **Quality Control** DAS QC8- Inspect parts - second check 0.00 120 20 40 *120* 14-12-09 9-89 OC 0.00 Memo

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Quality Control

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DQA:	Date:										DART	
					WORK ORDER NON	-CO	ONFO	RMANCE / UP	DATE			AEROSPACE
QA Closed:		Date:							W	ork Order up	odate only	
Work Orde	ır:				DISPOSITION							
			<i></i>	_	Rework]		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	0.				Scrap	1	!	Machining	Small Fab	Pro	Quality	
					Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR No.					Suspected Unapproved]		Large Fab	Composite		Supplier[
Root				Descr	ription of work order update		Initial	Actio	on	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descrip	otion	Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling						>						
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Operator												
Offset/Setup												
Process	_											
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Landin	g Gear				General					_	_	
ļ_	Bending				Bend		Folio/P	Program		Outside Dim	ensions	Pressure/Forced
	Centre No	ot Concer	ntric		BOM/Route		Grain		<u> </u>	Over/Under	tolerance	Set-up
_	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ct [Temperature/Cure
	Crimp/Kink/Ripple/Wave			Burrs		Inspecti	ion Incomplete/Unq	ualified	Part Lost/Mi	ssing	Weld	
	Cuffs				Contamination		Instruct	ions Incomplete/Un	ıclear	Part Moved		Wrong Stock Pulled
_اد.	Crushing			Countersink		Misalig	ned/off center		Positioned V	Vrong		
3 ·	Heat Trea	it			Cut Too Short		Mislabe	eled	-	Power Loss/	Surge	Other
	Inspection	n Strip in	Tube		Drawing		Misread	d				
	Marks/Ch	natter			Drill Holes		Off-set					
	Turning S	equence			Finish		Out of 0	Calibration				
	Wave/Twist in Tube				Fit/Function		Out of	Sequence				

Work Order ID 127021 *127021* Page 2 Wednesday, December 03, 2014 4:10:01 PM D3503-1 Accept Item ID: Setup Start *N900040100* **Revision ID:** Stop **Item Name:** Cup *40* **Start Oty: 40.00 Start Date:** 12/04/14 **Cust Item ID:** Required Date: 12/05/14 Req'd Oty: 40.00 *40* **Customer:** Reference: Start Run **Tooling:** Process Plan: Date: Date: **Approvals:** Stop SPC (Y/N): Date: Date: OC: Tool ID Reject Sequence ID/ Operation Set Up/ Tool # Plan Accept Reject Insp. Qty Stamp **Work Center ID** Code Qty Number **Description Run Hours** Identify as per dwg & Stock Location. WA 500 130 0.00 40 *120* 0.00 Packaging Memo -Packaging 140 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

140

Quality Control

QC

WILL.10

DQA:		Date:											
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / U	PDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	ar.				DISPOSITION				/PROCESS				
WORK OTGE	: r	 			Rework			Skid-tube	Crosstube		1	Water Jet	Engineering
Part No.					Scrap			Machining Small Fab		$\overline{}$	Pro	d. Eng. Coor.	Quality
				 -	Use-as-is			noforming	Finishing		1	re/Packaging	Other
NCR No.									Composite	_		Supplier	
Root				Desci	ription of work order update		nitial	Act	tion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector
Design													
Doc/Data				İ									
quip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
rocess													
upplier													
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ransport	_	1											
Inapproved		ļ				<u> </u>							
						FAI	ULT CAT	EGORY					
Landir T	ng Gear			_	General		١				1	<u></u>	
1	Bending				Bend	<u> </u>	1	rogram		<u> </u>	Outside Dim	⊢	Pressure/Forced
1	Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain				Over/Under	 -	Set-up
1	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			<u> </u>	Part Incorred	}	Temperature/Cure
}	Crimp/Kir	nk/Ripple	:/Wave	-	Burrs		1	on Incomplete/Ui	· ·		Part Lost/Mi	ssing	Weld
}	Cuffs				Contamination	<u> </u>	ł	ions Incomplete/	Jnclear	<u></u>	Part Moved	L	Wrong Stock Pulled
}	Crushing				Countersink		•	ned/off center			Positioned V	_	_
}	Heat Trea			ļ	Cut Too Short	<u> </u>	Mislabe			<u></u>	Power Loss/	Surge	Other
}	Inspectio	•	Tube	<u> </u>	Drawing		Misread	İ				·	
}	Marks/Ch			<u> </u>	Drill Holes		Off-set					···	
	Turning S			-	Finish	<u> </u>	i	Calibration				-	
	Wave/Twist in Tube				Fit/Function	L	Out of S	equence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Picklist Print

Wednesday, December 03, 2014 4:10:05 PM

Work Order ID: 127021

127021

Parent Item:

D3503-1

D3503-1

Parent Item Name: Cup

Start Date: 12/04/14

Required Date: 12/05/14

Start Qty: 40.00

Required Qty: 40.00

Page 1

Comments:

IPP Rev:A New Issue 06-05-04 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000		Purchased	No		100	f	42.7100	0.065	3			
N/20/D1	$\Omega\Omega\Omega$							**				

M304R1 000

304 round bar 1.00

Loc Code Location Loc Oty 42.71 MAT029 7.2 36 14.12.07 42.71 m128005 -

DQA:		. Date:											N/Q	DA DT
					WORK ORDER NON-	-CC	ONFO	RMANCE / UI	PDATE					AEROSPACE
QA Closed:		Date:							\	Vork Ord	ler up	odate only		
Work Orde	r:				DISPOSITION			AGAINST DEPARTMENT/PROCESS						
					Rework			Skid-tube	Crosstube		Water Jet		7	Engineering
Part No.					Scrap			Machining	Small Fab	Prod. Eng. Coor.		\exists	Quality	
					Use-as-is			noforming	Finishing	Red		re/Packaging	\exists	Other
NCR No.				_	Suspected Unapproved			Large Fab	Composite			Supplier		
Root		<u> </u>		Descr	ription of work order update	1	nitial	Act	ion	Sign	&	, , , , , , , , , , , , , , , , , , , ,		
Cause	Date Step Qty				or non-conformance	Ch	ief Eng	Descr	iption	Dat		Verification	1	QC Inspector
Design													\top	
Doc/Data														
Equip/Tooling		1												
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier								,						
Training														
Transport												-		
Unapproved													\perp	<u>.</u>
						FAL	JLT CA	regory						
Landin				_	General		l .		· ;:.	_		г		
-	Bending				Bend	\square		rogram	<u> </u>			ensions	_	Pressure/Forced
-	Centre No	ot Concer	ntric		BOM/Route	Щ	Grain		-	-		tolerance	_	Set-up
-	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>	Part In		⊢		emperature/Cure
-	Crimp/Kir	nk/Ripple	:/Wave		Burrs	-	·-	on Incomplete/Un	· -	Part Lo		ssing	_	Veld
-	Cuffs				Contamination	-		ions Incomplete/U	Inclear	Part M		L		Wrong Stock Pulled
-	Crushing			-	Countersink	\vdash	-	ned/off center	-	Positio		· ·	_	
-	Heat Treat				Cut Too Short	Ш	Mislabe		L	Power	LOSS/	Surge [<u> </u>	Other
-	Inspection Strip in Tube				Drawing		Misread	1						
-	Marks/Ch			-	Drill Holes	\vdash	Off-set	7 - 11 h A1						
	Turning S			<u> </u>	Finish	-		Calibration		<u></u>				
	Wave/Tw	ist in Tub	oe		Fit/Function		Out of S	Sequence						

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DART AEROSPACE LTD		Work Order:	127021
		ż	
Description: Cup		Part Number:	D3503-1
Inspection Dwg: D3503 Rev: A			Page 1 of 1
FIRST ARTIC	LE INSPECTION	N CHECKLIST	
X First	Article	Prototype	
Drawing A	Actual	Method of	

		Į.	:			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.875	+0.000/-0.005	. 873	_		6" Vern	€0-6
Ø0.750	+/-0.010	.753			~~	**
Ø0.257	+0.006/-0.001	.260	_		عد	**
0.488	+/-0.010	. 492	~		.e., 1	•••
0.094	+/-0.010	. 097				
0.063 Ref	Min 0.055 Max 0.0675	.060	~		~	ч.
R0.062	+/-0.010	.062	~		~~	
0.032 x 45°	+/-0.010 x +/-0.5°	1033	/		٧	u
			DAG			

			DAS		
Measured by:	36	Audited by:	20	Prototype Approval:	N/A
Date:	14.12-67	Date:	14-12-09	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.10.24	New Issue	KJ/EC/DD	
				V

DQA:	Date:												TQAG			
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only											
Work Orde	r:				DISPOSITION											
Part No					Rework Scrap Use-as-is Suspected Unapproved		Machining Small Fall Thermoforming Finishing		Crosstube Small Fab Finishing Composite	ab Pro ng Rec/Sto		Water Jet rod. Eng. Coor. ore/Packaging Supplier		Engineering Quality Other		
Root				Descr	iption of work order update		Initial	Act	ion		Sign &					
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption		Date	Verificati	on	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved											i sa t					
		<u> </u>	•	•		FAI	ULT CA	regory			•					
Landir	ng Gear				General											
	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube				Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislabe Misread Off-set	ion Incomplete/Ur ions Incomplete/U gned/off center eled d	•		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance et ssing /rong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
	[wave/[w	rist in Tul	oe e	1	Fit/Function	1	JOut of S	Sequence								

[•] H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

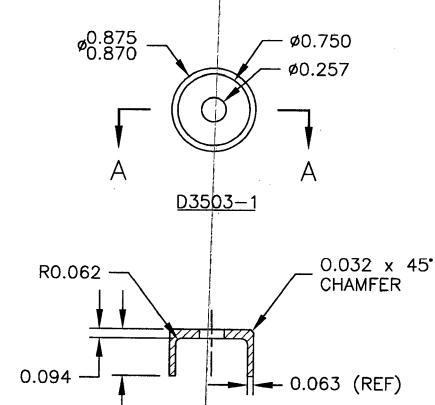


DESIGN DRAWN BY DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA CHECKED APPROVED DRAWING NO. REV. A D3503 SHEET 1 OF 1 DATE TITLE SCALE 06.04.19 CUP 1:1

NEW ISSUE

06.04.19

HELLIAM 06 0425 -



SECTION A-A

D3503-1 CUP

MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR (REF DART MATERIAL SPEC M304RX.XXX)

2) ALL DIMENSIONS ARE IN INCHES

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) BREAK SHARP EDGES 0.005 TO 0.010 MAX

0.488

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